

# Work Order ID 96988

\*96988\*

Page 1

Thursday, February 14, 2013 8:34:52 AM

Item ID: D119-827-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 2/13/2013 Start Qty: 1.00<sup>2</sup>

\*1\* (2)  
\*1\*

Cust Item ID:

Required Date: 2/14/2013 Req'd Qty: 1.00

Customer: CU-DAR001

Reference: RMA RA111483 - RETURN

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D119-827

C

\*SP

100

0.00

\*100\*

QC

Quality Control

Memo

0.00

INSPECT RA 111483 D119- 827-011 X 1 B#94334

Shd  
13219

REWORK

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

PULL D4704-041 FROM KIT AND REMOVE D4711-1 PIN

SCRAP PIN

REPLACE WITH NEW

ENSURE 0.095" GAP BETWEEN D4711-1 AND D4726-1

2 off 13-02-14

# Work Order ID 96988

\*96988\*

Page 2

Thursday, February 14, 2013 8:34:52 AM

Item ID: D119-827-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Tail Rotor Pedal Lockout Installation

Stop

\*NS2\*

Start Date: 2/13/2013 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 2/14/2013 Req'd Qty: 1.00

\*1\*

Customer: CU-DAR001

Reference: RMA RA111483

Approvals: Process Plan: *UMP*

Date: 13-2-14

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
16  
9-89 13/2/15

130

Pick Kit

0.00

\*130\*

Packaging

Memo

0.00

Packaging

2x

SP  
13-2-15

140

QC4- 100% Inspect kits for completeness

0.00

\*140\*

QC

Memo

0.00

Quality Control

DAS  
15  
9-89 13 2 19

2

# Work Order ID 96988

Thursday, February 14, 2013 8:34:52 AM

**\*96988\***

Page 3

Item ID: D119-827-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Tail Rotor Pedal Lockout Installation

Stop **\*NS2\***

Start Date: 2/13/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/14/2013 Req'd Qty: 1.00 **\*1\***

Customer: CU-DAR001

Reference: RMA RA111483

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

*SHIP*  
*Paperwork + Label - for MLS 13-2-15 (2)*

*13/2/19* *[Signature]*

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*CAG001*

*13/2/19* *[Signature]*

*MF*

*13-2-19*

# Picklist Print

Thursday, February 14, 2013 8:34:52 AM

Page 1

Work Order ID: 96988

Parent Item: D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 2/13/2013

Required Date: 2/14/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13-01-09 REV B  
JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-11A  
Bolt

Purchased

No

Each

376.0000

2 24 SP



Location

Loc Qty

Loc Code

FG

20

120731

20

ST514

106

123900

106

ST517

250

124221

250

4x

D119-827-011

Tail Rotor Pedal Lockout Installation

Manufactured

No

Each

0.0000

1 + 2 B96988 SP

MS14144L4

Nut

Purchased

No

Each

38.0000

2 24 SP



Location

Loc Qty

Loc Code

ST331

38

122378

3

123832

30

123900

5

3x  
1x

MS24665-153

COTTER PIN

Purchased

No

Each

190.0000

2 24 SP



Location

Loc Qty

Loc Code

ST323

190

107139

190

4x

NAS1149D0416J

Washer

Purchased

No

Each

374.0000

2 24 SP B-2-15

Location

Loc Qty

Loc Code

ST293

374

123741

374

4x

Handwritten notes and signatures at the bottom of the page, including 'D4710', 'D4721', and various initials and numbers.

Handwritten signature or mark at the bottom center.

# Picklist Print

Thursday, February 14, 2013 8:34:52 AM

Page 2

Work Order ID: 96988

Parent Item: D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout Installation

Start Date: 2/13/2013

Required Date: 2/14/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Washer

Purchased

No

Each

3,383.0000



8/16 SP



SM 2

## Location

## Loc Qty

## Loc Code

FP001

37

122441

37

GA

12

122452

12

ST294

3334

116304

12

123355

4

123900

1

124198

3317

NAS6604D16

Bolt

Purchased

No

Each

34.0000



24 SP/B-2-15.



SM 2

## Location

## Loc Qty

## Loc Code

ST277

34

123023

4

123832

30

4X

~~D4711-043 x 2~~ B# 13-2-19

D4749-1 x 2  
SM 2

B# 95751 SP

D4703-041 x 2  
SM 2

B# B97372 SP

D4711-043 x 2 B# 93144

B-2-15.

B-2-19.

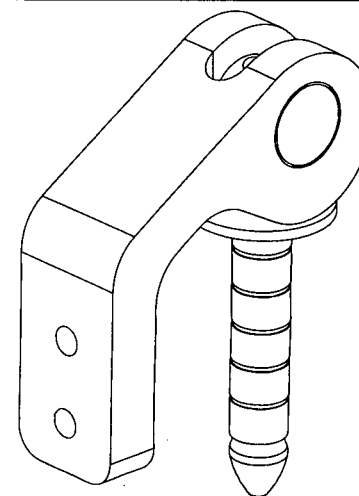
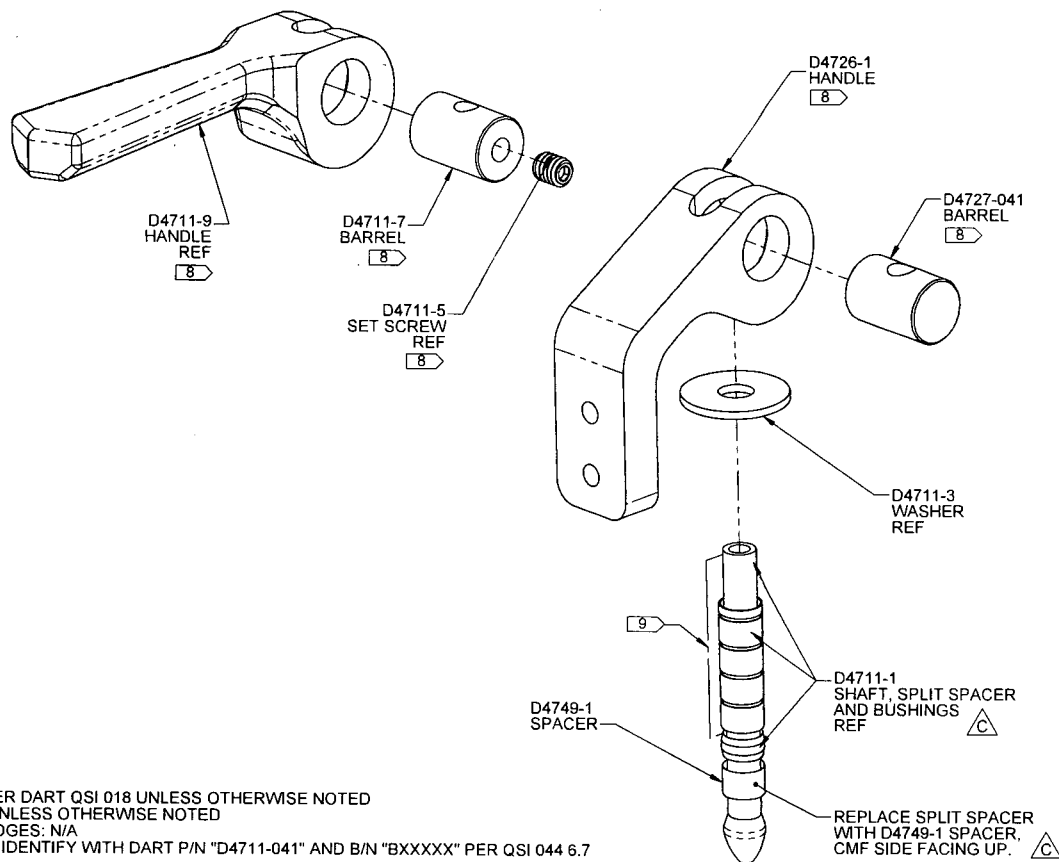


Thursday, February 14, 2013 8:34:52 AM

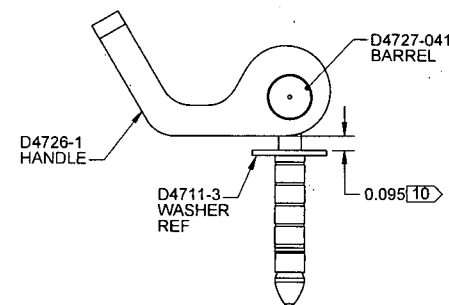
Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



**D4711-041  
EXPANDABLE PIN ASSEMBLY, MODIFIED  
(CLOSED POSITION)**



**D4711-041  
EXPANDABLE PIN ASSEMBLY, MODIFIED  
(OPEN POSITION)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.19 lbs
- 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.  
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.  
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.  
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
- 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
- 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8. ADDED NOTE 10. PICTORIAL UPDATE	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4711</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ADJUSTABLE DIAMETER PIN</b>	NTS
DATE	13.02.12	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

## 4.0 PARTS LIST

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

## 5.0 WEIGHT AND BALANCE

The following are the net weight increases associated with D119-827-011 kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg

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Revision: C  
Date: 13.01.02

## Melanie Fauteux

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**From:** Eric Downing <edowning@dartaero.com>  
**Sent:** Wednesday, February 13, 2013 8:50 AM  
**To:** Melanie Fauteux; 'L Lacelle'; 'Marc Bellavance'  
**Cc:** psmith@dartaero.com; 'Mike Petsche'; Sian Willems  
**Subject:** D119-827-011 pedals locks  
**Attachments:** D4711 REVISION.PDF

Hey Mel/ Linda

Here is the rework scheme that should be done for the returned D119-827-011 B94334

Pull form D119-827-011 B94334 RA111483 D4704-041 B94865

- Remove D4711-1 and scrap
- Re assemble D4711-1 as per latest drawing (the 1 which is attached) use ALL NEW HARD WEAR
  - And note in work order to ensure to allow 0.095" gap between D4711-3 & D4726-1
- Pick new hard ware for D119-827-011 kit and restock
- The D4704-041 will need a new work order
- New D119-827-01 will need a new work order and paper work and labels

Hope this is clear enough. If there are any questions please come and see me.

Thanks

**Eric Downing**  
QC Corrdinator



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